

Work Order ID 79623

79623

Page 1

January-30-12 2:41:32 PM

Item ID: D3806-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 30/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 13/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00
100
 Cold Saw Memo 0.00 OK 12/02/14 20 10
 Hyd Mech Cut blanks at 43.600"

110 0.00
110
 HAAS 1 Memo 0.00 OK 12/02/13 20 10
 HAAS CNC vertical machine #1 1-Mill as per folio FB070 & dwg
 FOLIO REV: 4A
 DWG REV: B
 2-Deburr as required

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

79623

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 30/01/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 13/02/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

enl 12/02/15

120

OC

Memo

0.00

20 ~~6~~

Quality Control

QC8- Inspect parts - second check

0.00

SL 12-02-15

130

OC

Memo

000

20

Weld per dwg A/R Hardcoat S.S. Batch:

0.00

133

Large Fab

Memo

0.00

Large Fab

1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#:

Dart Aerospace Ltd

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 30/01/2012 Start Qty: 20.00

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Cust Item ID:

Required Date: 13/02/2012 Req'd Qty: 20.00

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Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
137 *137* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo	0.00 0.00							

EL 12-2-17 (220)

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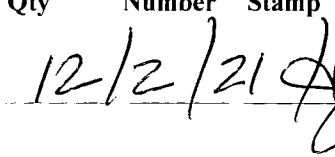
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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/2/21 

12-02-17
20

Dart Aerospace Ltd

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Picklist Print

January-30-12 2:41:36 PM

Page 1

Work Order ID: 79623

79623

Parent Item: D3806-1

D3806-1

Parent Item Name: Bar

Start Date: 30/01/2012

Required Date: 13/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 08-07-21 new issue DD verified by:ec

IPP Rev:B 08-09-23 redesign DD verified by:EC

IPP Rev:C 08-09-30 redesign DD verified by:EC

D 11.06.03 re-design EC verified by:DD

rev.b as per dwg DD verified by:EC

IPP rev

IPP Rev:E 11.10.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	0.0000	3.66	77.05263			

M304B0 250x0 500

304 BAR .250 x .500

**

M120488

83.8 OK 12/02/14

Dart Aerospace Ltd

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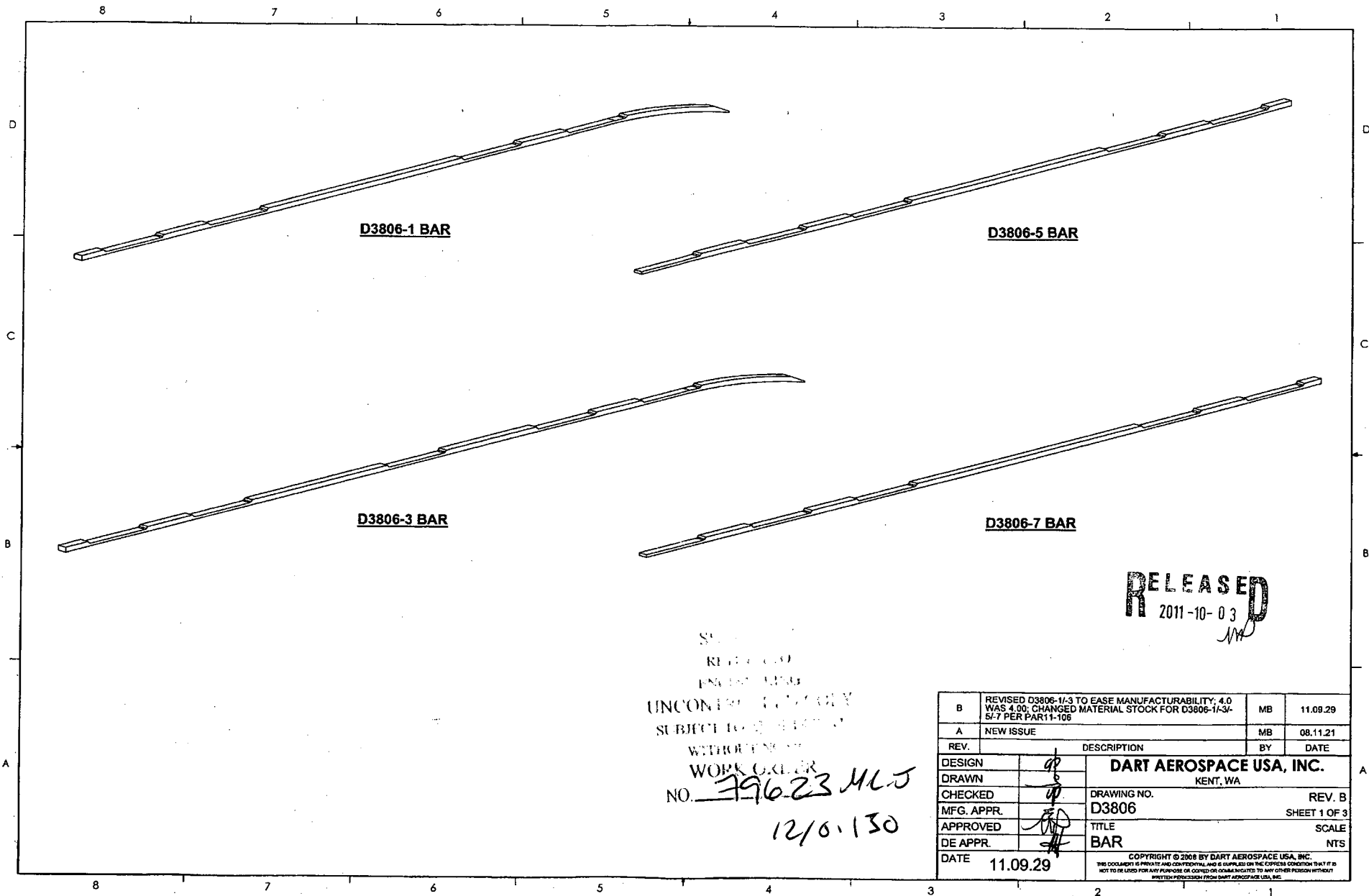
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RELEASED
2011-10-03

STANDARD
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FSA/ST/ALND
UNCONTROLLED COPY
SUBJECT TO REVISION
WITHOUT NOTICE
WORK ORDER
NO. 39623 MLC
12/01/30

B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PART 11-106	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	gpb	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	gpb	DRAWING NO.	REV. B
CHECKED	gpb	D3806	SHEET 1 OF 3
MFG. APPR.	gpb	TITLE	SCALE
APPROVED	gpb	BAR	NTS
DE APPR.	gpb	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	11.09.29		

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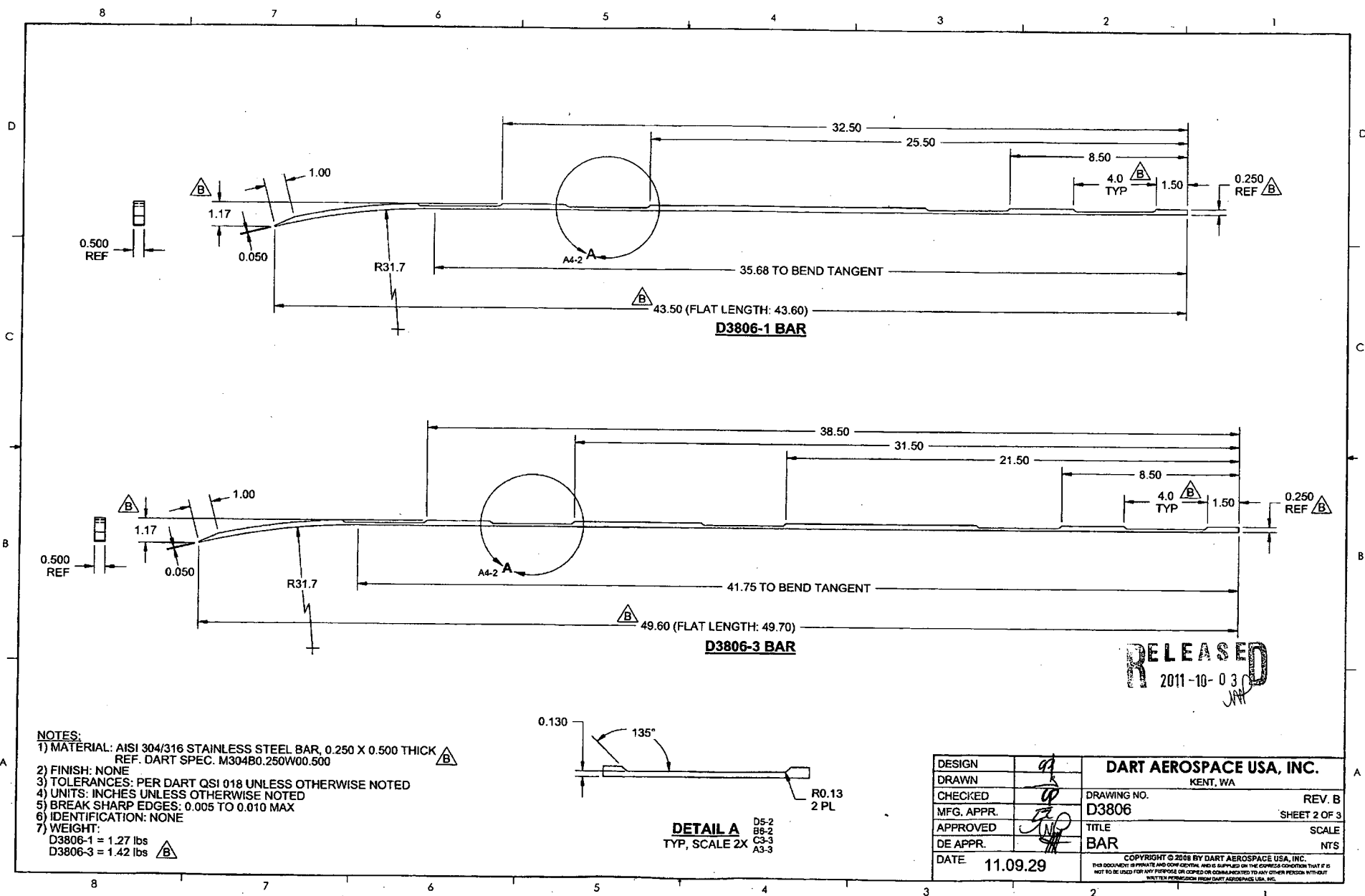
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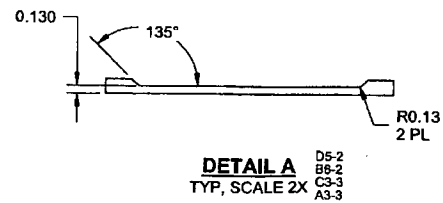
NOTE: Date & initial all entries

79623



RELEASED
2011-10-03

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3806	REV. B
MFG. APPR.		TITLE BAR	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.	
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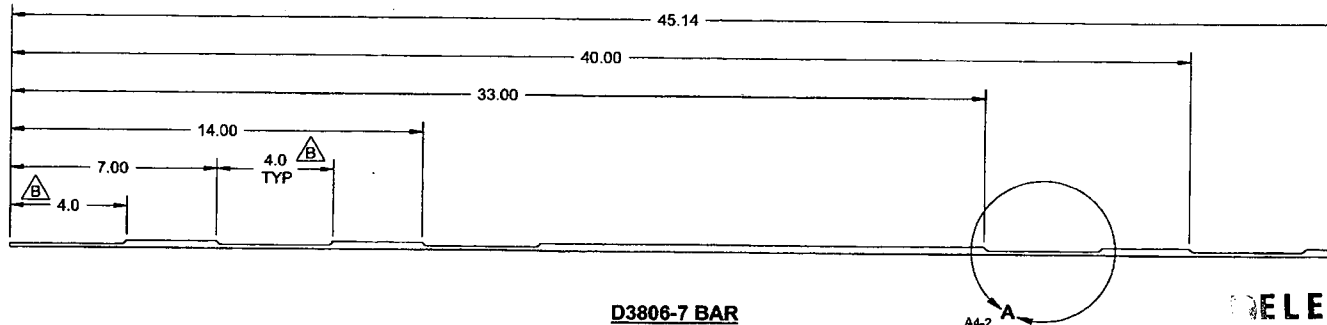
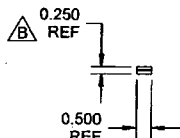
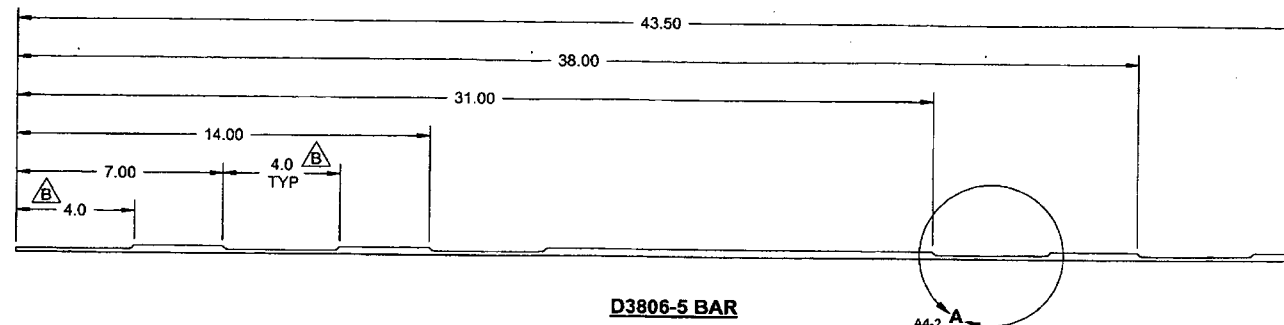
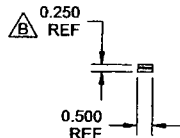
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- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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